

Date: Wednesday, 8/15/2007 6:18:13 AM
 User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LATCH BRACKET
Job Number	: 33893		
Estimate Number	: 10994		
P.O. Number	: N/A	Part Number	: D2583
This Issue	: 8/15/2007 S.O. No. : N/A	Drawing Number	: D2583 REV. B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 30716	Material	: N/A
Written By	: <u>ml 07-08-15</u>	Due Date	: 8/22/2007
Checked & Approved By	:	Qty:	50 Um: Each
Comment	Est: C 00.11.01 Removed P/O for Powder Coat- in house processDM Est: D 06.07.21 Waterjet EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S040	5052-H32 .040 Sheet
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Comment: Qty.: 0.1227 sf(s)/Unit Total : 6.1373 sf(s)
 Material: 5052-H32 (QQ-A-250/8) 0.040" thick
 (M5052H32S040) Batch: ml 07-08-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2583
 Dwg Rev: B
 Prog Rev: B

ml 07-08-15

(51)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07-08-15

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

ml 07-08-15

Coated
(X51)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr
 Form on CNC Brake as per Dwg D2583

ml 07/08/20 (x51)

ml 07/08/21 (51)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LATCH BRACKET

Job Number: 33893

Part Number: D2583

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counters

Comment: INSPECT WORK TO CURRENT STEP

En 07/09/03 (X57)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

2T 07-08-25

(51)

8.0

POWDER COATING

POWDER COATING



M105068



(51A)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m.h

07/08/29

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/08/29 (51)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

07/08/29 (54)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



(51)

Comment: FINAL INSPECTION/W/O RELEASE

07/08/30

Job Completion

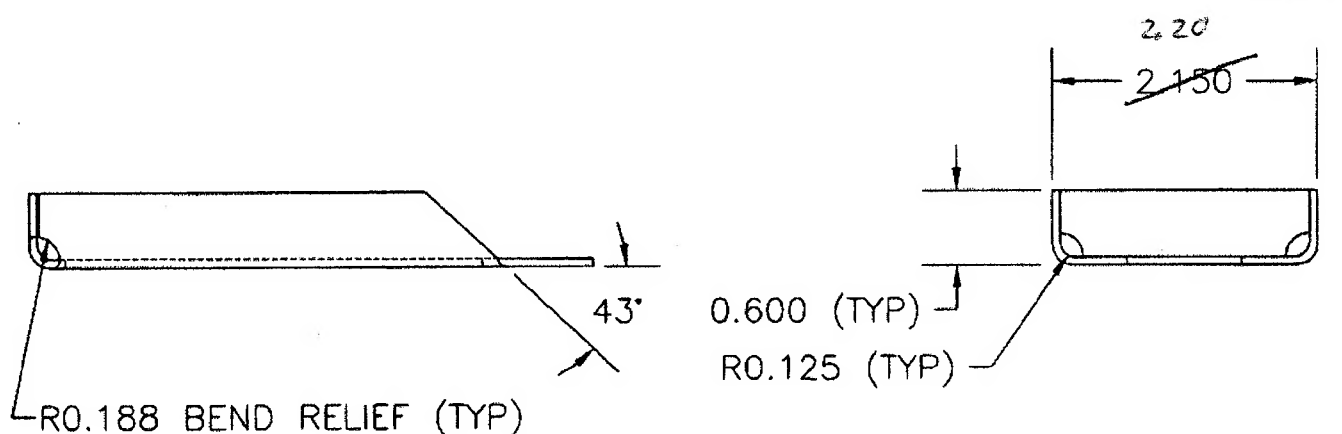
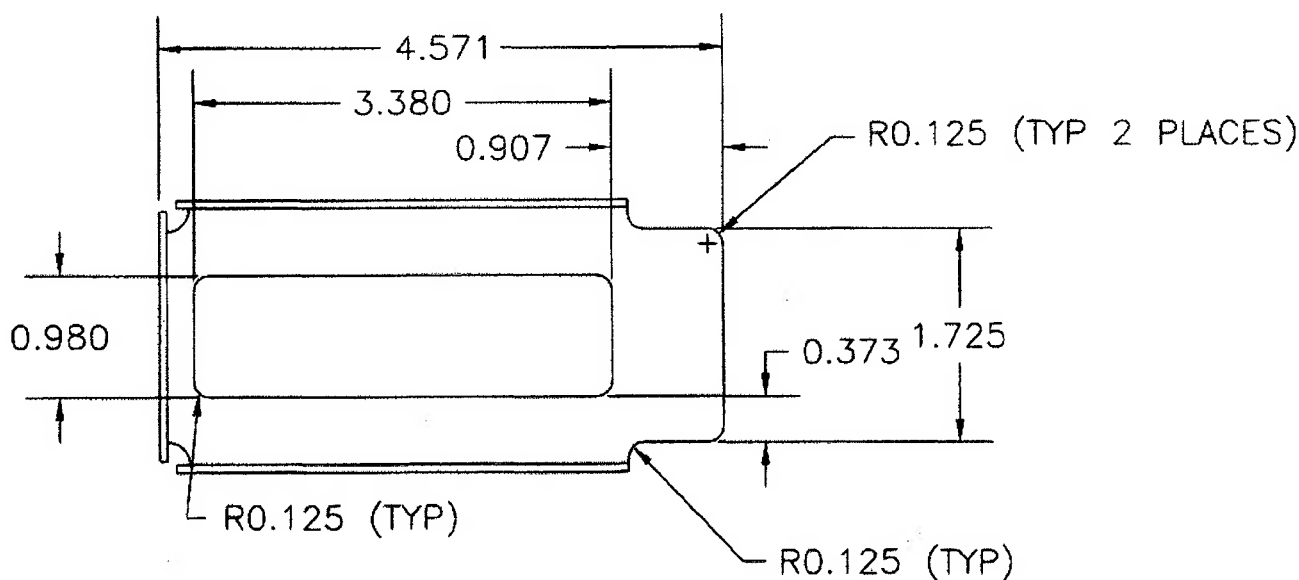


UL 07-08-30



RELEASED
KE 99.02.25

DESIGN	MIKE M.	DRAWN BY	RF	DART AEROSPACE LTD
CHECKED	CP	APPROVED	KE	HAMKESBURY, ONTARIO, CANADA
DATE	99.02.22	TITLE	LATCH BRACKET	REV. B
		DRAWING NO.	D2583	SHEET 1 OF 1
		SCALE	2:3	
A	96.07.10	NEW ISSUE		
B	99.02.22	CHANGE OF FINISH (PER TSR A887)		



MATERIAL: 5052-H32 (QQ-A-250/8) 0.040 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED